

# INFRALIT PE 8796

## Superdurable Polyester Powder

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<b>PAINT TYPE</b>	INFRALIT PE 8796 superdurable polyester powder is based on polyester resin and due to its special hardener it is free of TGIC. At elevated temperatures the powder melts, cures and forms the final paint film.
<b>USAGE</b>	INFRALIT PE 8796 is suitable for objects which require a first class weather-resistant coating, e.g. on areas with high UV-radiation level.
<b>SPECIAL PROPERTIES</b>	INFRALIT PE 8796 forms a mechanically and chemically resistant paint film which has good corrosion resistance and very good colour stability and gloss retention also in outdoor conditions that are unusually severe. INFRALIT PE 8796-00 is the general variant suitable for both corona and tribo spraying. Variants PE 8796-02 and PE 8796-09 are suitable for corona only. INFRALIT PE 8796-24 has solar reflective pigmentation.
<b>APPROVALS</b>	Qualicoat approval number P-1249, Cat. 3, Cl. 2. GSB MASTER material licence. Registration number 145g.

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**TECHNICAL DATA**

<b>Colours</b>	By agreement.
<b>Gloss 60°</b>	65 - 85
<b>Spreading rate</b>	6 - 10 m <sup>2</sup> /kg depending on the film thickness
<b>Film thickness</b>	Recommended film thickness is 70 - 110 µm.
<b>Curing time</b>	15 - 25 min/180°C (metal temperature). 10 - 20 min/190°C (metal temperature).
<b>Storage</b>	The storage life is minimum 18 months in dry and cool conditions when the temperature during storage and transportation is max. 25°C. The recommended expiry date of the powder coating that has been stored according to the instructions is shown on the package label.

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**SAFETY PRECAUTIONS**

The powder itself is non-flammable, but with air it can form an explosive mixture that in presence of adequate ignition energy ignites. The lower explosive limit for polyester powder is about 80 g/m<sup>3</sup> (Bundesanstalt für Materialprüfung). Ventilation of the spray booth should be adjusted so that the concentration of powder in the air is less than 50% of the lower explosive limit value. On calculation of the powder concentration in the spray booth, the powder deposited on the workpiece is not taken into account.

In order to avoid the discharge of powder from the booth into adjacent working spaces, the speed of air flow in the apertures of the booth must not fall below 0.5 m/s.

Spray painters should wear dust masks and protective gloves. Any spatter of powder on the skin should be washed off with water and soap.

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**DIRECTION FOR USE****Surface preparation**

COLD-ROLLED STEEL: Degreasing and zinc phosphating or alternatively a suitable conversion treatment.

ALUMINIUM: Degreasing and chromating or alternatively a suitable conversion treatment.

**FILM PROPERTIES**

Substrate chromated aluminium (100 x 300 x 0.6 mm), film thickness 70 µm, stoving 15 min/180°C. Testing 1 h after stoving:

**Typical values**

Flexibility (Erichsen, ISO 1520)	over 6 mm
Impact resistance ( ASTM D 2794; 15.9 mm diameter)	
- direct	over 2,5 Nm
- reverse	over 2,5 Nm
Flexibility (ISO 1519)	less than 5 mm
Adhesion (cross-cut test, EN ISO 2409)	GT 0

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The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).

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